

ay, 25/09/2006 11:10:45 AM

Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28626
 Estimate Number : 10907
 P.O. Number : N/A
 This Issue : 25/09/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 28626
 Written By : W
 Checked & Approved By : W
 Comment : Est. A05.01.13 New issue KJ/JLM
 Est Rev:B Now on Waterjet 06-09-25 JLM

Drawing Name : PANEL
 Part Number : D33305
 Drawing Number : D3330 REV B1
 Project Number : N/A
 Drawing Revision : B1
 Material : N/A
 Due Date : 05/10/2006 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S125 1010-1025 sheet .125



Comment: Qty.: 0.8316 sf(s)/Unit Total : 6.6528 sf(s)
 1010-1025 sheet .125
 (M1010S0125)
 Batch: M102247 ml 061003

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3330
 Dwg Rev: B1
 Prog Rev: B1

ml 061003

(8)

2-Deburr if necessary

mf 061023

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 061004

(8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

061004 (8)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr 061004 (8)
 Form as per Dwg D3330 SD 061025 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/09/2006 11:10:45 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 28626

Part Number: D33305

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



26-10-25



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS23*

CPL 06.10.26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



2

Comment: FINAL INSPECTION/W/O RELEASE

27 04/10/26

Job Completion



U 06.10.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

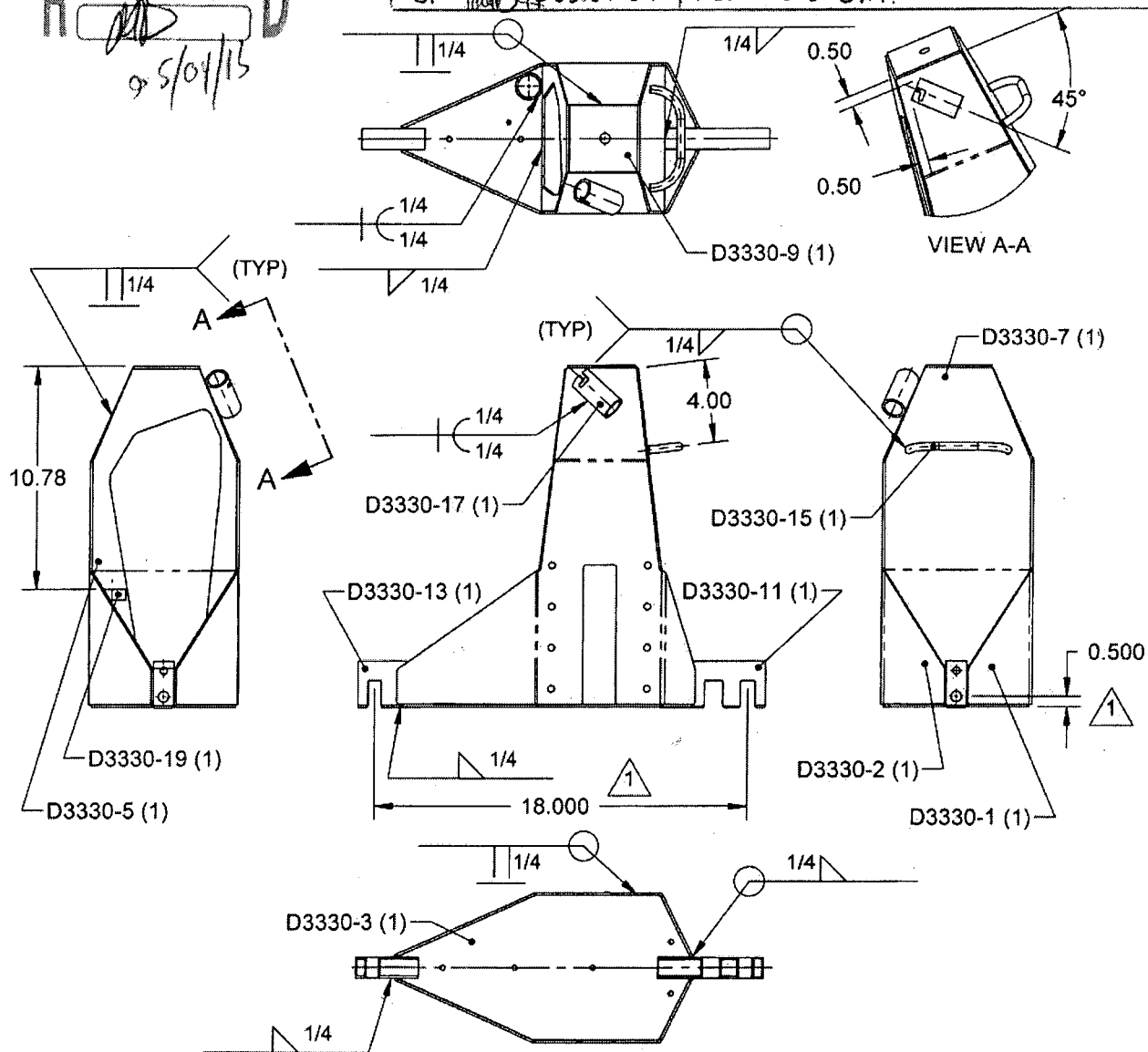
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED R	APPROVED [Signature]	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26	TITLE FRAME WELDMENT SCALE 1:8		
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	
BI	05.07.04	ADD 1.605 DIM.	

RELEASED
9/5/04/15



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

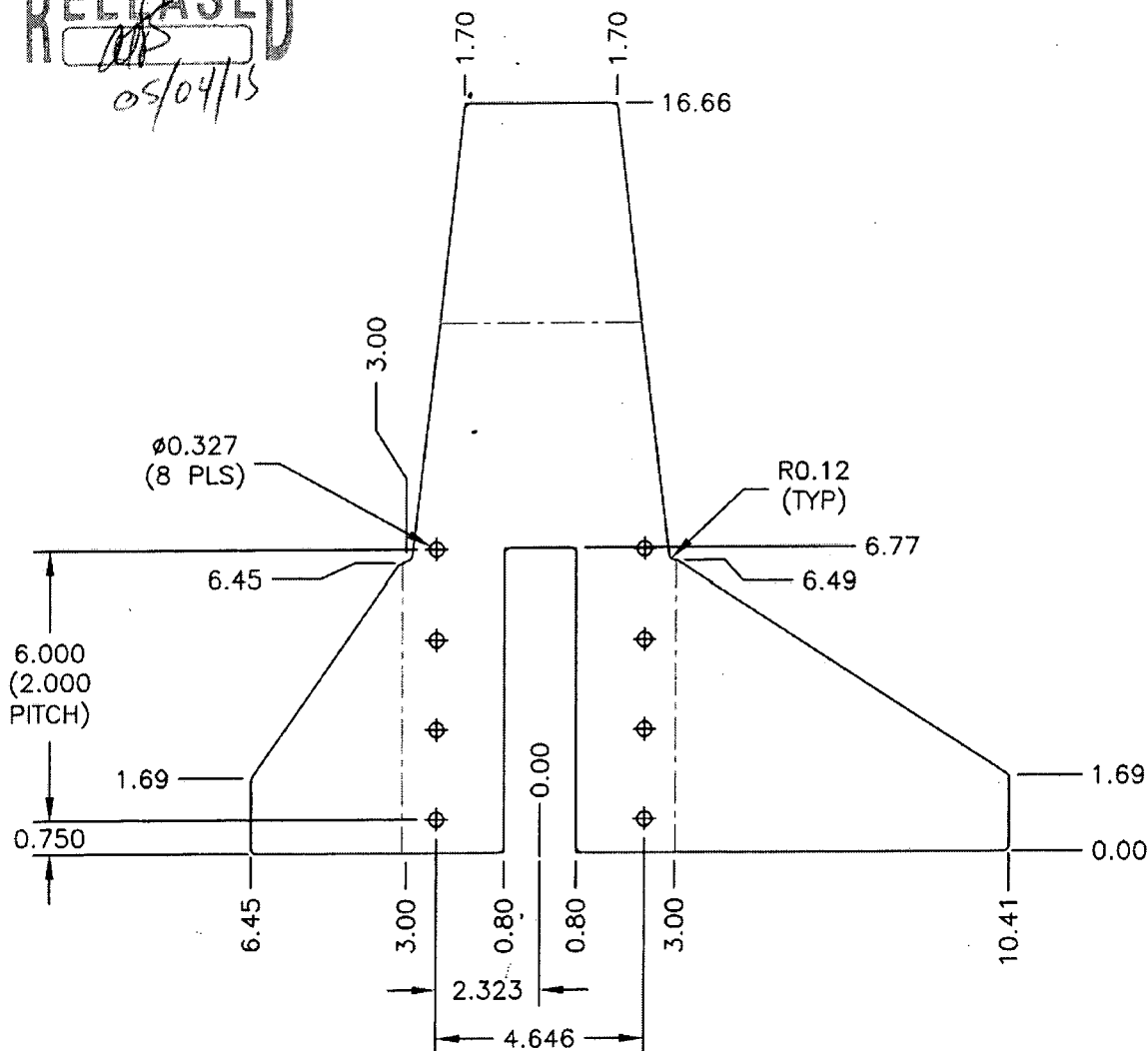
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

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05/04/15**D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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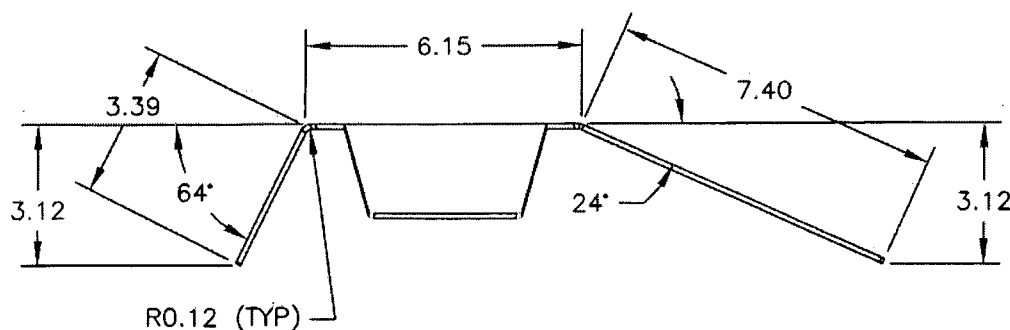
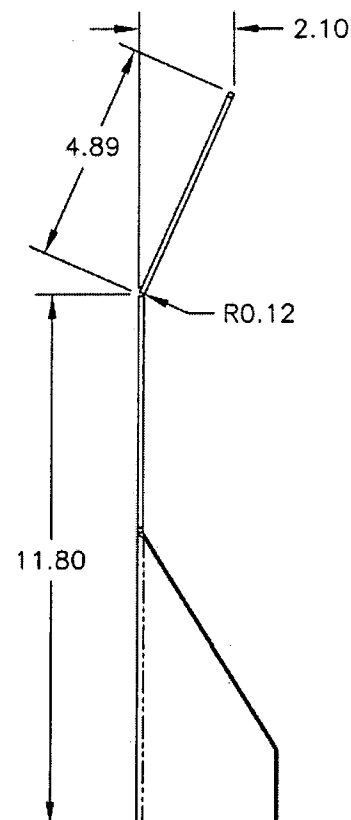
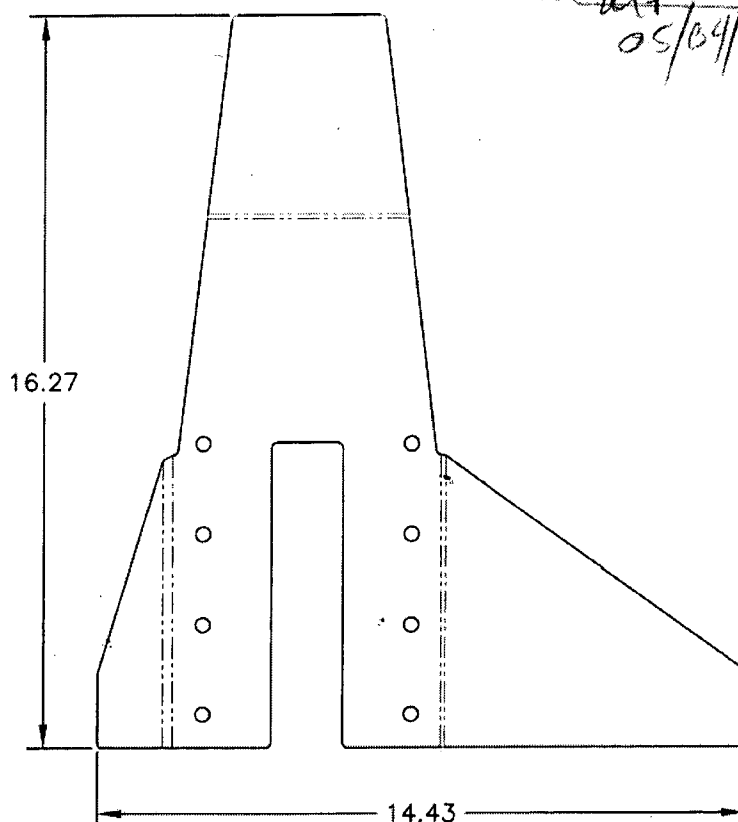
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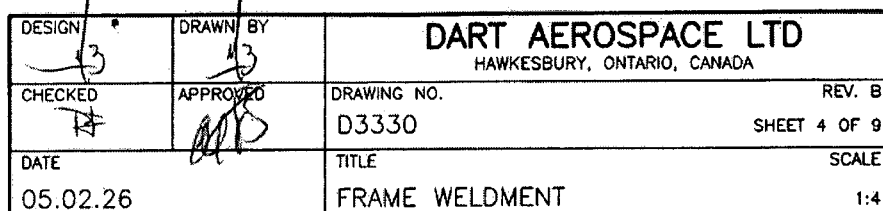


D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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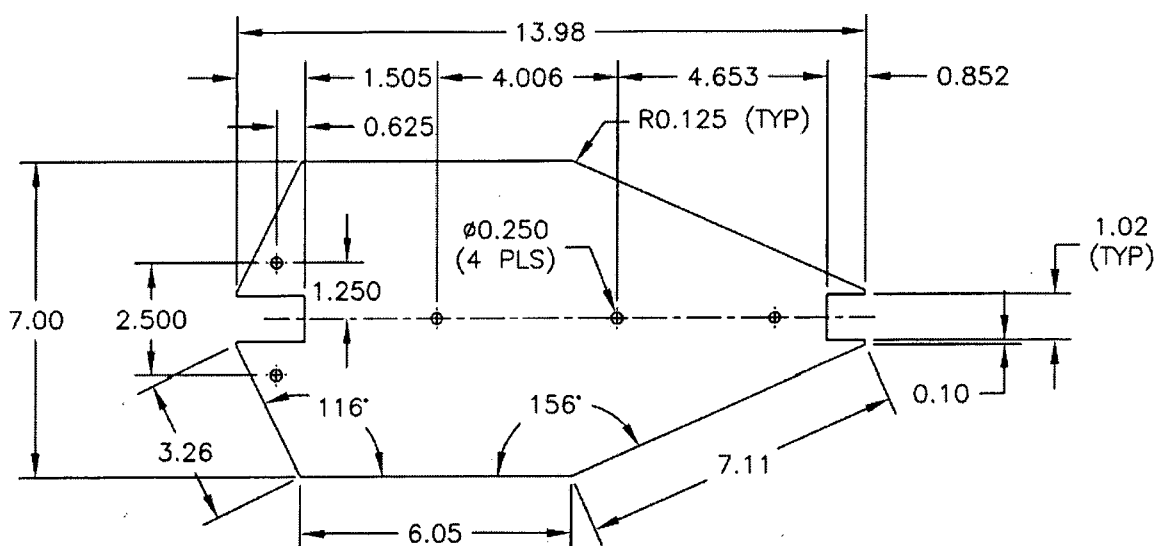
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05/04/15



D3330-3 PLATE

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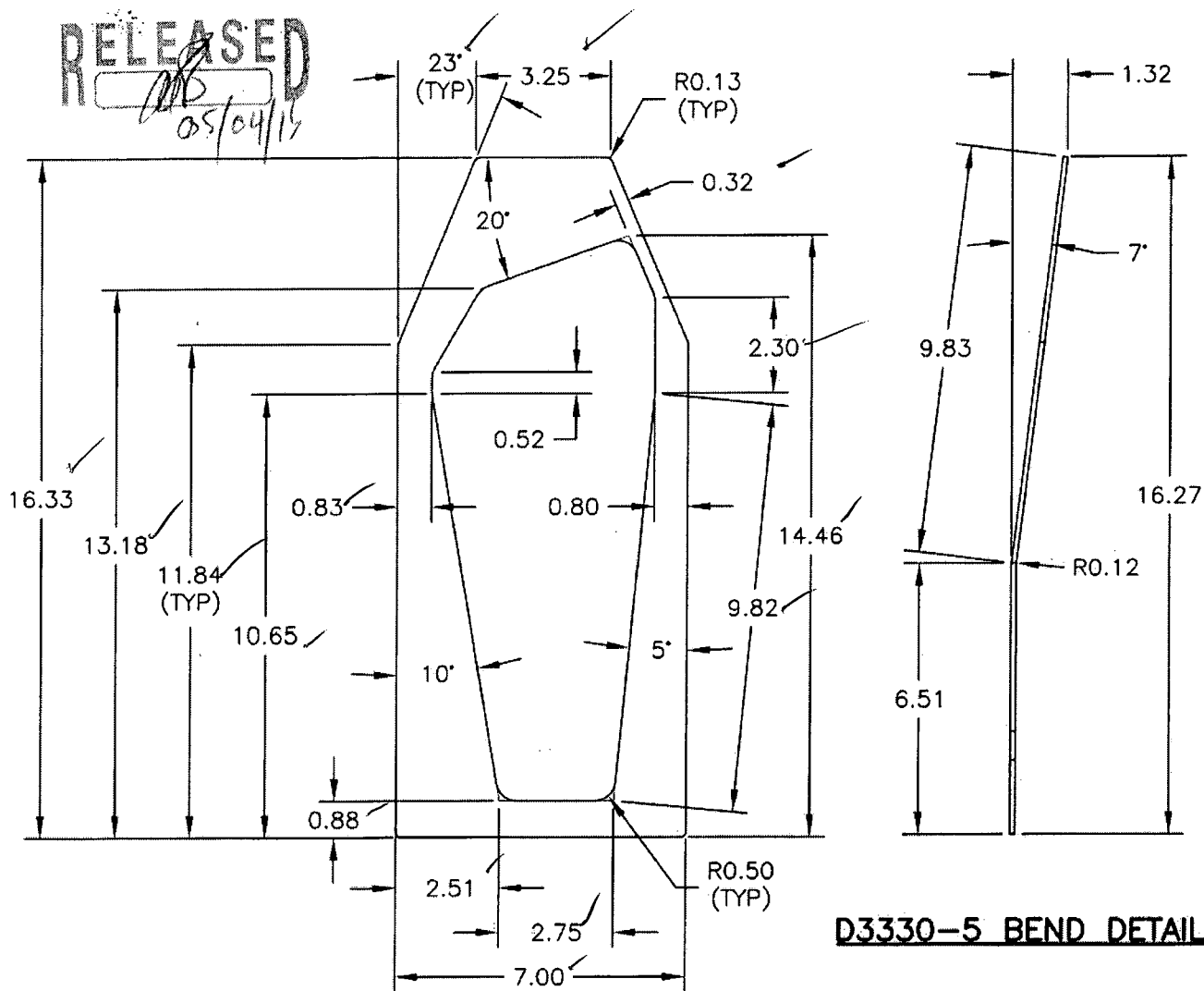
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40 21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4

**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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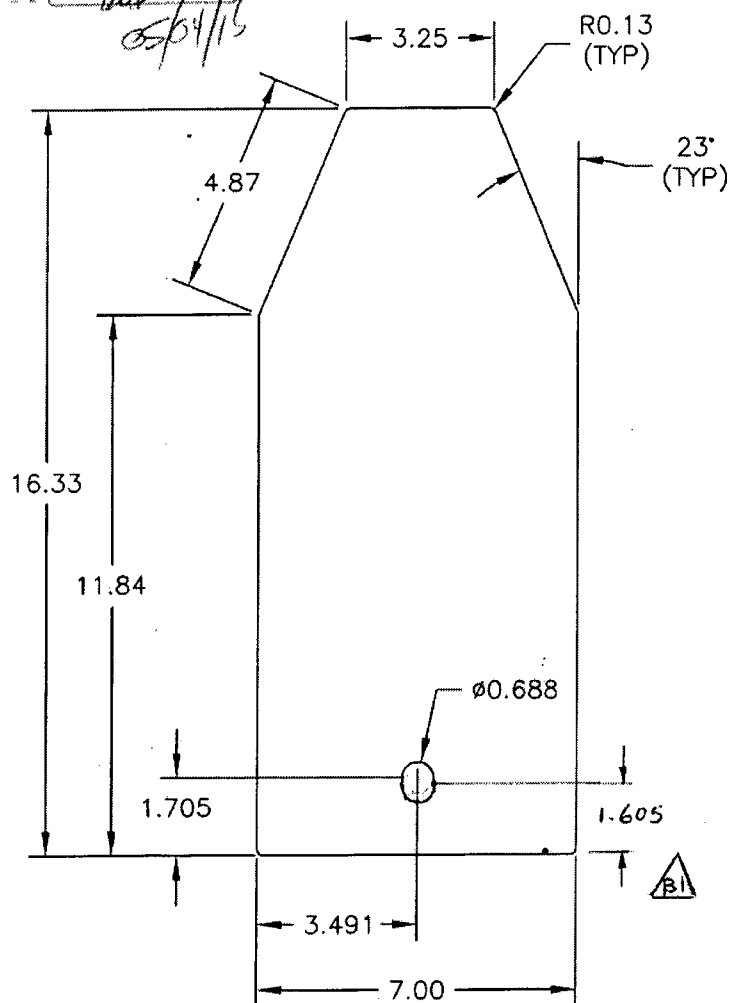
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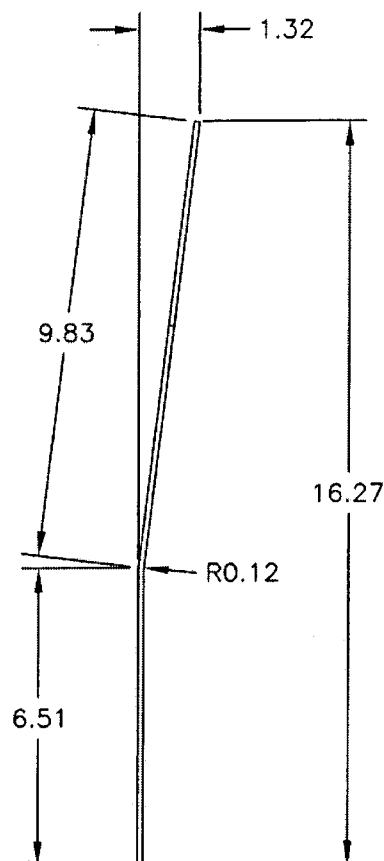


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DATE 05.02.26		TITLE FRAME ASSEMBLY	SCALE 1:4

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05/04/13



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

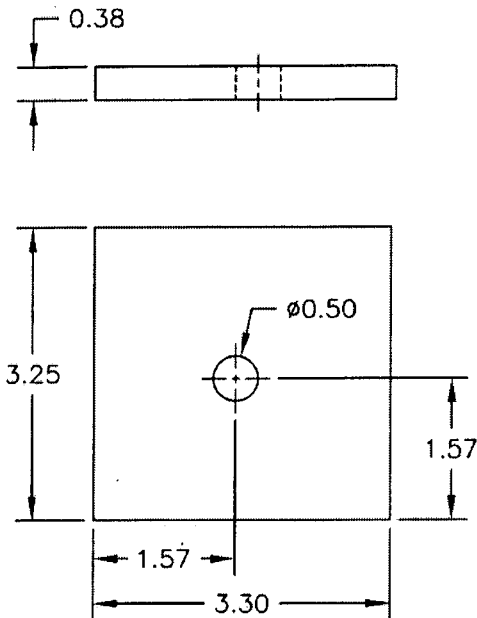
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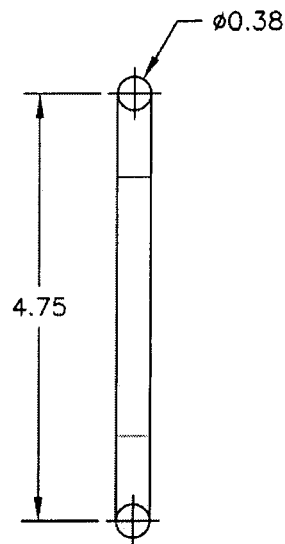
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DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:2



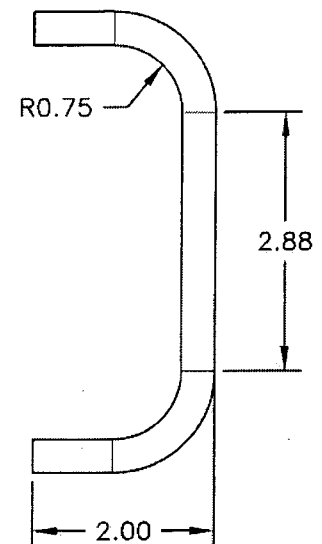
1 **D3330-9 TOP PLATE**



2 **D3330-15 HANDLE**

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[Signature]

05/04/15



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL SHOP COPY
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

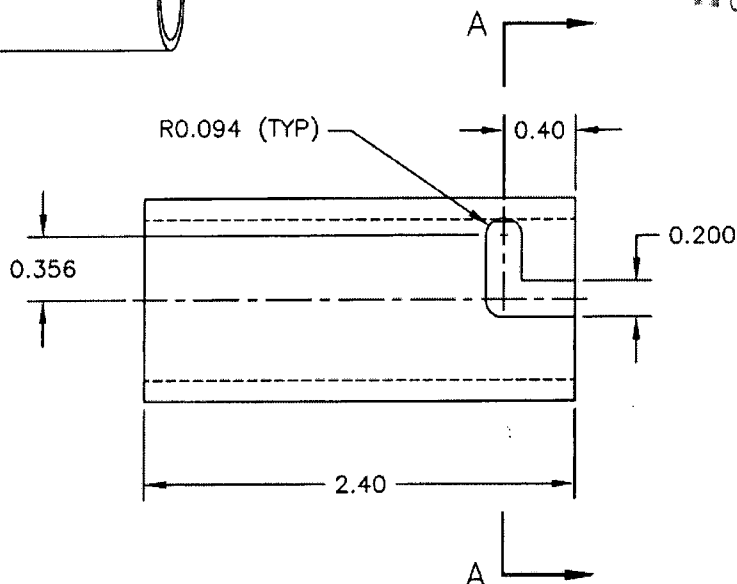
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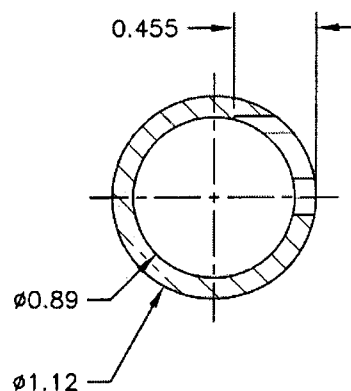
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1

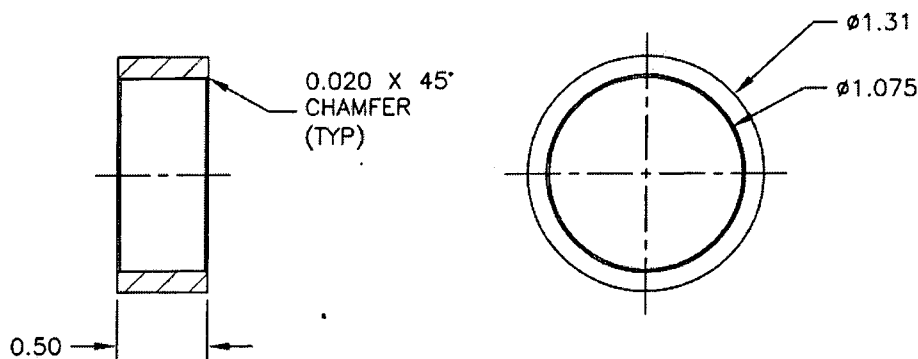


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[Signature]
05/04/15



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

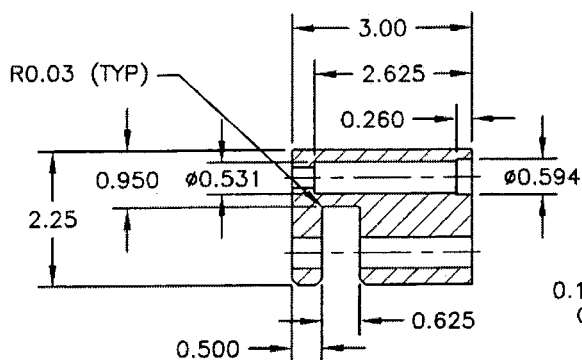
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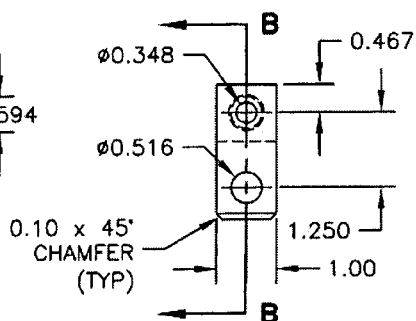


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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3

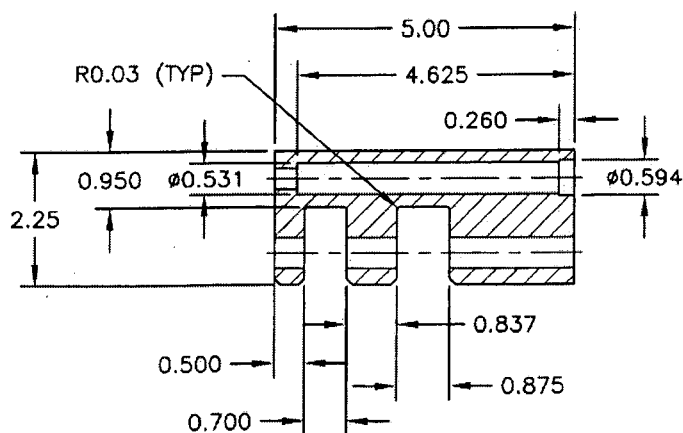
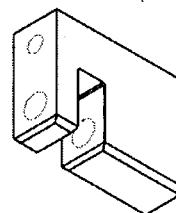


SECTION B-B

D3330-13 SHORT PIN BRACKET

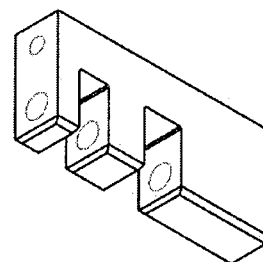
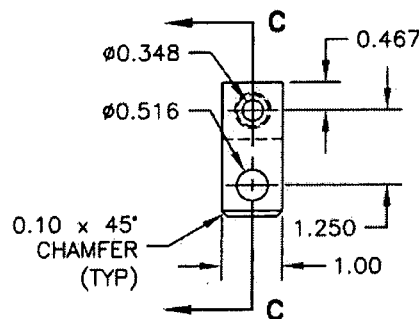


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05/04/15.



SECTION C-C

D3330-11 LONG PIN BRACKET



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
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DART AEROSPACE LTD	Work Order: 28626
Description: Frame weldment	Part Number: D3330-5
Inspection Dwg: D3330, Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>MA MA</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>B 10 04</i>	Date: <i>06-10-04</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	